














Date: Thursday, 6/21/2007 2:29:02 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: MIRROR ARM LONG (S-76)
Job Number	: 33053		
Estimate Number	: 11893		
P.O. Number	: N/A	Part Number	: D2261
This Issue	: 6/21/2007 S.O. No. : N/A	Drawing Number	: D2261 REV A1
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : SMALL /MED FAB	Drawing Revision	: A1
Previous Run	: 28495	Material	: N/A
Written By	: <u> </u>	Due Date	: 6/28/2007 Qty: 2 Um: Each
Checked & Approved By	: <u> </u>		
Comment	: Est: D 02.04.15 Added dwg Rev.A1 NG		
Additional Product			
Job Number: 			
Seq. #:	Machine Or Operation:	Description :	
1.0	M304TR0500W035	304 RD Tube .500 x .035W	
			
Comment: Qty.: 3.1281 f(s)/Unit Total : 6.2561 f(s) Material: 304/316 SS tubing 0.500" Dia. x 0.035" wall (M304TR0500W035) Batch No: <u>M104640</u> <u>FF 07-06-26</u>			
2.0	BRAKE NC	NC BRAKE	
			
Comment: BRAKE NC Punch tube 304/316 with 2B finish Form as per dwg D2261 Deburr <u>FF 07-06-27</u>			
3.0	QC5	INSPECT WORK TO CURRENT STEP	
			
Comment: INSPECT WORK TO CURRENT STEP <u>FF 06-27 (2)</u>			
4.0	POWDER COATING	POWDER COATING	
			
Comment: POWDER COATING Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3 <u>OK/M 07-06-28</u>			
5.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION	
			
Comment: INSPECT POWDER COAT <u>07/6/28 (2)</u>			
6.0	D2022101	Spacer	
			
Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s) Spacer Pick: Qty Part Number Description Batch <u>13 30543</u>			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: EC Date: 07/06/25
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MIRROR ARM LONG (S-76)

Job Number: 33053

Part Number: D2261

Job Number:



Seq. #:

Machine Or Operation:

Description :

4 D2022-101 Spacer

7.0

A1449

Grommet



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Grommet

Pick:

Qty Part Number Description Batch

2 A1449 Grommet

M1487

Perf/28 (2)

8.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per dwg D2261

FF 07-06-29 2

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En 02/06/28 (2)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

Perf/29

(2)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



(2)

Comment: FINAL INSPECTION/W/O RELEASE

En 02/06/29

Job Completion



U 07-06-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

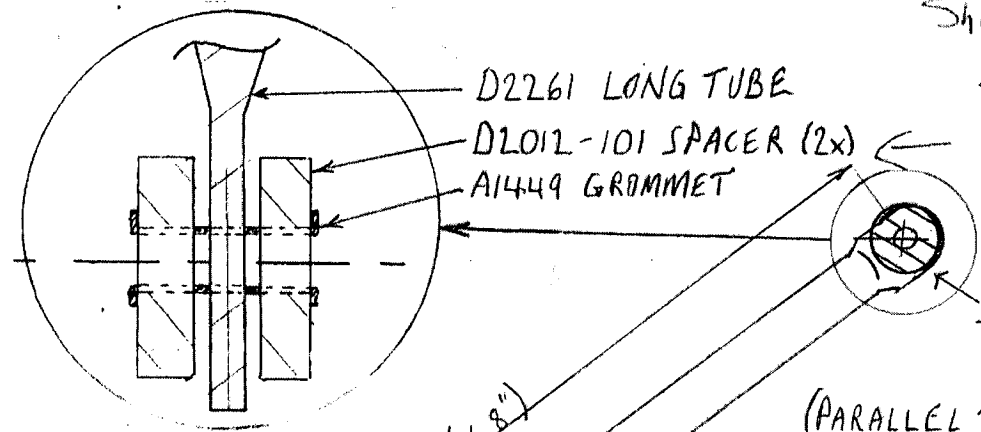


DART

DRAWN <i>M. Cohen.</i>	DART AERO ACCESSORIES INC VICTORIA INTERNATIONAL AIRPORT, CANADA	
DESIGN	DRAWING NO. <i>D2261</i>	REV. <i>A</i>
<i>Aug 10/94</i>	TITLE <i>LONG TUBE</i>	
SHEET <i>1</i> OF <i>1</i>		

<i>A1</i>	<i>CP</i>	<i>0203.22</i>	ADD FINISH
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Should be D2022-101
SPACER CP 0301.06



ASSEMBLE PER DETAIL
AND SWAGE GROMMET
(2 LOCATIONS)

STANDARD FLARE
BOTH ENDS

(PARALLEL TO PLANE
OF BENDING)

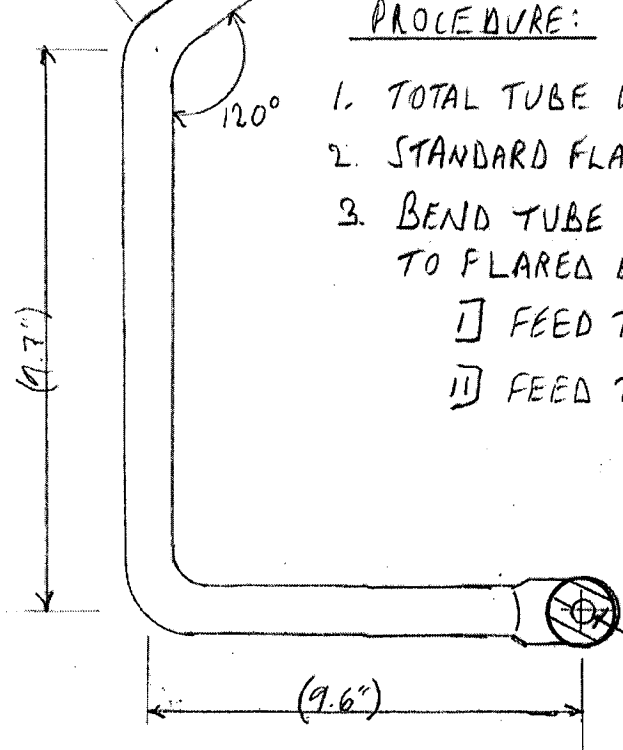
MATL: 304 SS 1/2" OD x .035" WALL TUBE
FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7)
PER DART QST 005 4.3 A1

PROCEDURE:

1. TOTAL TUBE LENGTH = 35.75"
2. STANDARD FLARE BOTH ENDS
3. BEND TUBE WITH BENDS PARALLEL TO FLARED ENDS.

I FEED THRU 11", BEND 90°

II FEED THRU 19 3/4" (TOTAL), BEND 60°



.257" Dia Both Ends

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *33053*